



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3315

Job Sheet 171983



Part No: 646.3315

Job Qty: 16 ea

Part Name: Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 2/28/18

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/07 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea	2/27/18	2/27/18	0.00	0.00	Start Up Machining-1		mon 18/03/18
100	Bandsaw	16 pcs	2/27/18	2/27/18	0.00	0.64	Bandsaw1		"
110	CNC Vertical Machining	16 pcs	2/27/18	2/27/18	0.51	11.67	HAAS1-1		"
130	QC	16 pcs	2/27/18	2/27/18	0.00	0.00	QC8 Machining-1		18/03/21
140	Outsource	16 pcs	2/27/18	2/27/18			MEI001-VC	PO89376	CT 18/03/21
150	Packaging	16 pcs	2/27/18	2/27/18	0.00	0.00	Packaging2		APR 18/04/09
155	QC	16 pcs	2/27/18	2/27/18	0.00	0.00	QC5	QUG	18
160	SprayPaint	16 pcs	2/28/18	2/28/18	0.00	0.55	Spray Paint		APR 17/2018
170	QC	16 pcs	2/28/18	2/28/18	0.00	0.00	QC14		APR 23 2018
180	Packaging	16 pcs	2/28/18	2/28/18	0.00	0.00	Packaging3-CKL		APR 23 2018
190	QC21-SA	16 Ea	2/28/18	2/28/18	0.00	0.00	QC21		APR 23 2018

Part Op 100 - Cut Blank at 2.600"

Descriptions: 110 - 1-Machine per folio FB147

140 - HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED

160 - PRIME AS PER DWG, SEE NOTE #4

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

SPRAY PAINT

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	3.4720 ft (.217 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MSTEEL-A2-B0.500X1.250	3	69	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.325inches $\pm$ 0.005	0.330 0.320		
2	Blade	30.000Degrees $\pm$ 0.500	30.500 29.500	Angle	
3	Blade	0.375inches $\pm$ 0.005	0.380 0.370		
4	Blade	2.460inches $\pm$ 0.010	2.470 2.450		
5	Blade	1.817inches $\pm$ 0.005	1.822 1.812		
6	Blade	1.192inches $\pm$ 0.002	1.194 1.190		
7	Blade	0.250inches $\pm$ 0.002	0.252 0.248		
8	Blade	0.256inches $\pm$ 0.002	0.258 0.254		
9	Blade	0.290inches $\pm$ 0.002	0.292 0.288		
10	Blade	0.940inches $\pm$ 0.010	0.950 0.930		
11	Blade	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter	
12	Blade	55.600Degrees $\pm$ 0.500	56.100 55.100	Angle	

Plex 2/9/18 3:01 PM Dart.Gagnon.Michelle



Container No: 8051528



Part: 646.3315

Job No: 171983

Serial No/Batch: 8051528

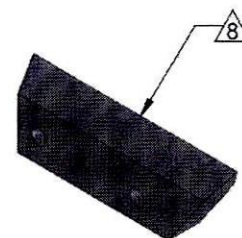
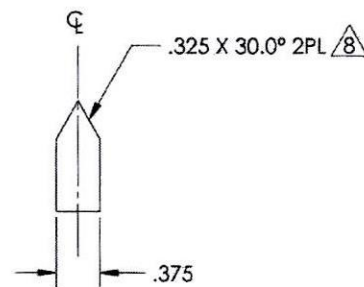
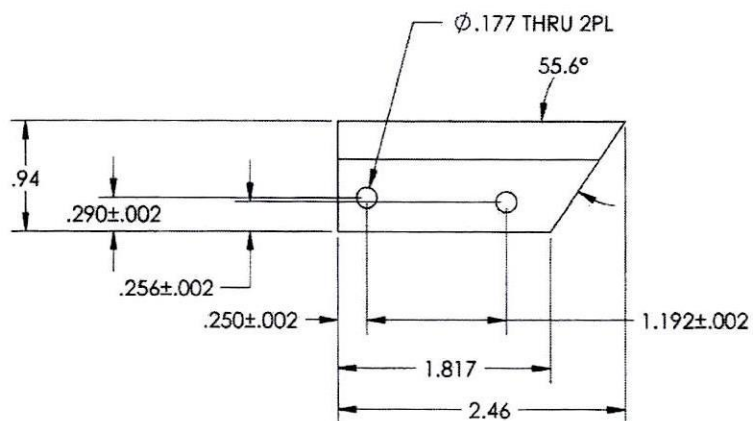
Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K84 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/15/18

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646.3315

ORIGINAL DATE: 08-24-06		3030 ENTERPRISE CT.	
DRAWN BY: C. HUFF		SUITE A	
CHECKED BY: P. BRAVO		VISTA, CA 92081	
DRAWING APPROVAL: P. BRAVO		(760)-724-5300	
DESIGNED BY: P. BRAVO		APICAL INDUSTRIES, INC.	
DATE: 08-24-06		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	REV. A	SCALE: NONE	SHEET 7 OF 8

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
326369	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
39376	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

VAC HARDEN

HARDEN AND TEMPER

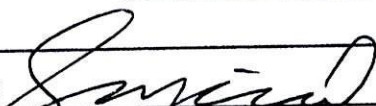
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	8	60 - 62 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
132	37	646.3315 (16) 646.3315 JOB. 171983 REF S051528 (16) 646.3316 JOB. 171984 REF S053063 (100) 646.9711 JOB. 171175 REF S050304 1 BOITE DE CARTON

9/4/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



METCOR
7

DATE: 2018-04-04

APPROUVÉ

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
326369	1

CLIENT / customer 215

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39376	N/A	A2		
SPECIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPECIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
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COMMENTAIRES / comments

VAC HARDEN 1800F, 1:30 HR
DOUBLE TEMPER 400F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
326369	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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APPROUVÉ par / Approved by:

Isabel Otero
QA Technician

DATE: 2018-04-05



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039376

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO039376

PO Date: 3/21/18

Due Date: 4/16/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171984	646.3316	Blade HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	4/16/18	16 pcs	0 pcs	16 pcs	\$2.36742424/pcs	\$37.88
						✓ 16x		AT 18/04/09		
2	171175	646.9711	Blade PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	4/16/18	100 pcs	0 pcs	100 pcs	\$2.36742424/pcs	\$236.74
						✓ 100x		AT 18/04/09		
3	171983	646.3315	Blade HEAT TREAT AS PER DWG 646.3300 FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	4/16/18	16 pcs	0 pcs	16 pcs	\$2.36742424/pcs	\$37.88
						✓ 16x		AT 18/04/09		

DAS
11
9-89